

Work Order ID 55501

January 19, 2010 1:46:47 PM

Page 1

Item ID: D412-630-031

Accept

Revision ID:

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/19/10 Start Qty: 2.00

Required Date: 1/25/10 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date: 10-1-19 Tooling:

QC:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

S 10/01/03

~~EP 10/01/29~~ (2)
KJ for MF 10/02/03

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

EP 10/01/29 (2)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

****ensure tension to retract step is 11 to 18 lbs ****

27-10/01/25

S 10/02/03

x2
(54)

+2

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 55501

January 19, 2010 1:46:47 PM

Page 2

Item ID: D412-630-031

Accept

Setup Start

Revision ID:

Stop

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/19/10 Start Qty: 2.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-1-20

sf (2x)

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) Subd3

A2
LH

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-031

Location: _____

PPP Rev: _____

P 11/2/13 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

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Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03 *[Signature]**MF*
10-2-3

W/O:		WORK ORDER CHANGES					
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Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN310-4		Purchased	No			130	Each	38.0000	2.0000			
											10-1-28	
NUT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse


ST 38
112969 10
113237 8
113422 20

Purchased No 130 Each 20.0000 4.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 20
105280 ? 2
110552 ? 2
111060 16

AN310-5

NUT

10-1-28 \$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3C5A <i>83</i>		Purchased	No			130	Each	909.0000	6.0000			
Bolt												

10-1-28 SD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	909	
111424	8	
111707	69	
112314	1	
<u>113121</u>	231	<i>b</i>
113149	300	
113644	300	

AN44-C12 *41*



eyebolt

Purchased No

130 Each 29.0000 2.0000



10-1-28

SL(24)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	29	
<u>111176</u>	9	
111888	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4C15		Purchased	No			130	Each	22.0000	2.0000			
BOLT											10-1-28	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

22

111303

10

113618

12

AN5C11
BOLT

Purchased No

130

Each

37.0000

2.0000

10-1-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37

103248

5

111279

20

113422

12

AN5C15
BOLT

Purchased No

130

Each

27.0000

2.0000

10-1-28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

10121

2

110552

25

January 19, 2010 1:46:51 PM

Shop Packet Print

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960C10	711AS1149C0363R	Purchased	No			130	Each	0.0000	14.0000			
WASHER												
AN960C516	41	Purchased	No			130	Each	219.0000	2.0000			
WASHER												

M113422 10-1-28 SP

10-1-28 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 219
102842 119
112532 100

2

D3454-1	41	Manufactured	No			130	Each	28.0000	2.0000			
Bushing												

10-1-28 (2X) SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 28
44588 2
46135 6
53745 20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3454-3 <i>82</i>		Manufactured	No			130	Each	34.0000	4.0000			
												
Bushing												

10-1-28 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

34

48125

34

130

Each

24.0000

4.0000



4

10-1-28 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

24

46137

1

53697

23

130

Each

31.0000

8.0000



4

10-1-28 SP

(24)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

31

46138

31

4

D3454-5



Bushing

Manufactured No

D3455-1



Spacer

Manufactured No

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3455-3		Manufactured	No			130	Each	29.0000	4.0000			
<div>  </div>												
<div> Spacer </div>												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

48126

29

29

130

Each

2.0000

2.0000

D3462-041

Manufactured No



Bracket Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

46462

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21043-3		Purchased	No			130	Each	4,480.000	6.0000			
											10-1-28	
5 #2 Nut												

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 4400

111819 70

112243 29

112314 4301

MS24665-227

#2

Purchased

No

130

Each

44.0000

4.0000



#2 COTTER PIN



10-1-28 SP (24)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 44

111359 14

113422 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS24665-229 +2		Purchased	No			130	Each	266.0000	4.0000			
COTTER PIN												

10-1-28

SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

266

111041

266

130

Each

294.0000

2.0000

4

10-1-28

SP

NAS1515H5 +1

Purchased

No

Washer

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG

44

103286

17

103691

27

Main Warehouse

ST

250

109430

250

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3463-041		Manufactured	No			110	Each	3.0000	2.0000			
Step Weldment Assembly												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

53585

3

3

D3443-043 Manufactured No

110

Each

0.0000

2.0000

Strut Weldment Assembly

D3443-041 Manufactured No

110

Each

1.0000

2.0000

Strut Weldment Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

GA

53696

1

1

10-1-28 SP

B 54233 10-1-28 SP

8/10/129
 B54235

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3443-9		Manufactured	No			110	Each	18.0000	4.0000			
Pin												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST
 48124
 53502

18
 8
 10

110

Each

12.0000

4.0000

2

10-1-28

D3454-7

Manufactured

No

Bushing

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST
 46132

12
 12

110

Each

31.0000

4.0000

4

10-1-28

D3455-1

Manufactured

No

Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST
 46138

31
 31

4

W/O:		WORK ORDER CHANGES					
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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3465-1		Manufactured	No			110	Each	63.0000	2.0000			
Washer												

10-1-28 *[Signature]*

Warehouse
Location

Main Warehouse

ST

63

41692

1

46134

62

2

AN4CH3

Purchased

No

110

Each

31.0000

4.0000



10-1-28

[Signature]

SS Bolt

Warehouse
Location

Main Warehouse

ST

31

111978

31

4

AN4C14

Purchased

No

110

Each

17.0000

2.0000



10-1-28

[Signature]

BOLT

Warehouse
Location

Main Warehouse

ST

17

110552

17

2

W/O:		WORK ORDER CHANGES					
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Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN310-4		Purchased	No			110	Each	38.0000	2.0000			
NUT												

10-1-28

[Signature]

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 38

112969 10

113237 8

13422 20

AN310-7 Purchased No

110 Each 33.0000 2.0000



NUT



2

10-1-28 *[Signature]*

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 33

103286 13

111916 20

MS24665-227 Purchased No

110 Each 44.0000 2.0000



COTTER PIN



2

10-1-28 *[Signature]*

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 44

111359 14

113422 30

2

January 19, 2010 1:46:52 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2010 1:46:52 PM

Work Order ID: 55501



Parent Item: D412-630-031



Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS24665-302		Purchased	No			110	Each	118.0000	2.0000			
Cotter Pin												



10-1-28

sl

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	118	
111359	18	
113644	100	

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

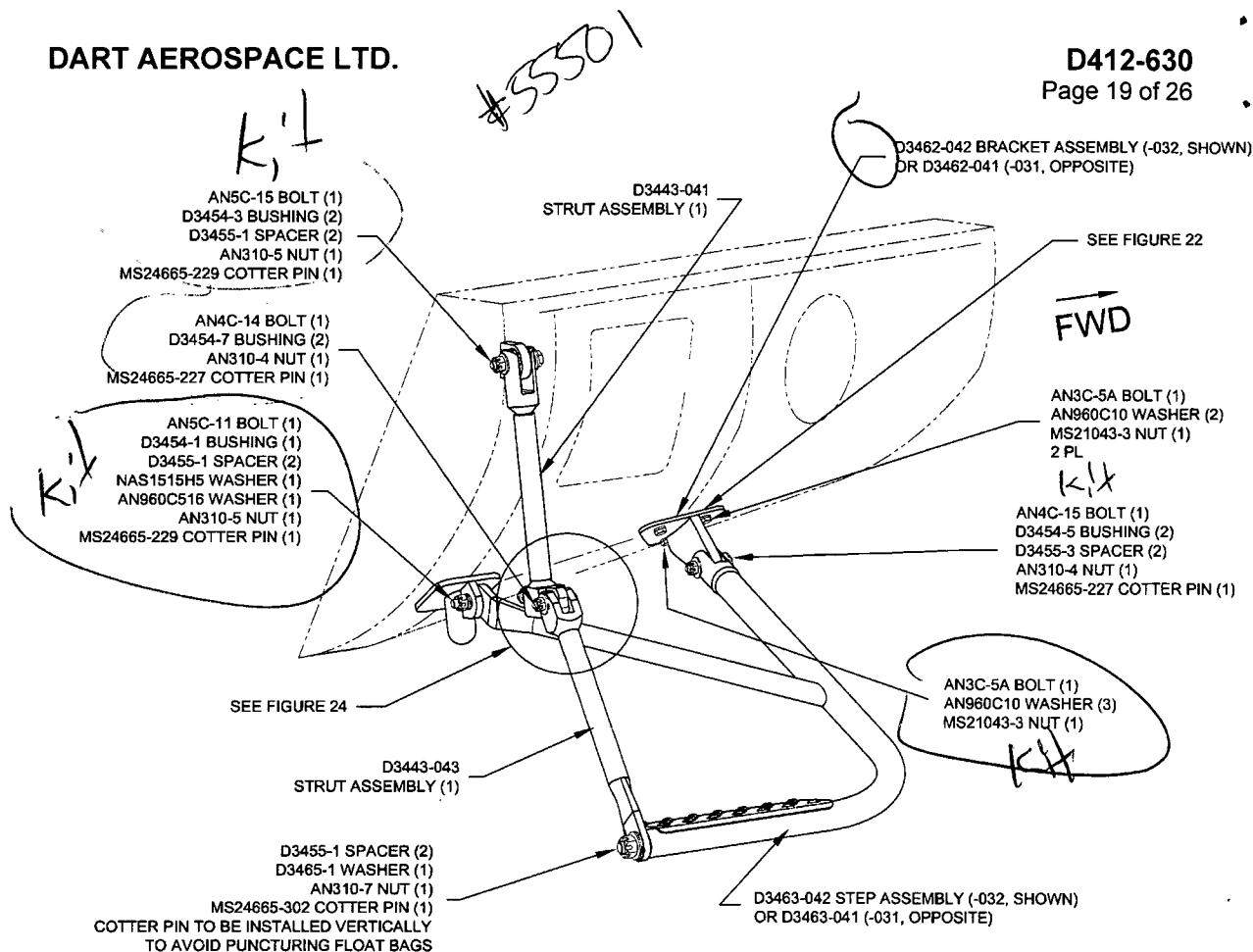


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

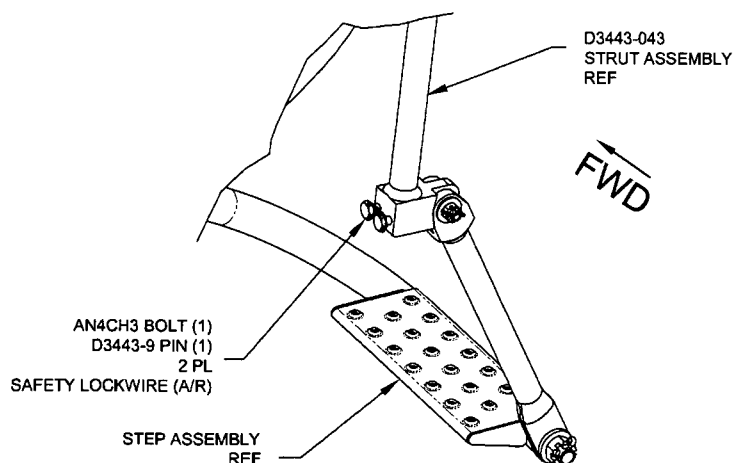


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Revision: **M**
Date: 08.12.12

S

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
(4) 6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
4		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
(1) 2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
(1) 2	2	MS24665-227	COTTER PIN -1
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN -
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries